

Date: Thursday, 12/14/2006 3:46:22 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : STEP SPACER
 Job Number : 29978B
 Estimate Number : 10378
 P.O. Number : N/A Part Number : D30653
 This Issue : 12/14/2006 S.O. No. : N/A Drawing Number : D3065 REV. B
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
 Previous Run : 28939B Material : N/A
 Due Date : 1/12/2007 Qty: 60 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est: C 02.11.01 Incorporated D3066-1 IPP KJ/RF
 Est Rev: D Now on Water Jet 06-04-11 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.2287 sf(s)/Unit Total: 13.7214 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: m102448

ml 06 12 19

(60)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: 6

Prog Rev: 13

ml 06 12 19

(60)

2-Deburr if necessary

SAD 06/12/22

60

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 12 19

(60)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 06/12/20

(60)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

SAD 06/12/22

(60)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-3 PAR #: N/A Fault Category: Prod / Pass ^{med & SMT} NCR: Yes No DQA: FD Date: 07/02/13
 QA: N/C Closed: FD Date: 07.02.14

NCR: <u>29978B</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/12/20</u>	<u>3.0</u>	<u>All parts are scrap do to wrong thickness of material (Qty 60)</u>	<u>Initial</u>	<u>destroy & replace Make sure its the right thickness .040"</u>	<u>ml</u> <u>06/12/20</u>	<u>NA</u> <u>06/12/20</u>	<u>Initial</u>	<u>06/12/20</u>

NOTE: Date & initial all entries

Date: Thursday, 12/14/2006 3:46:22 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 29978B

Part Number: D30653

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SD 07/02/08 (60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11/07/12/12 (60)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YSL YL

07/02/12 (60)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Rye 2/12

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

E Bay 12/13 (60)

CE

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-02-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

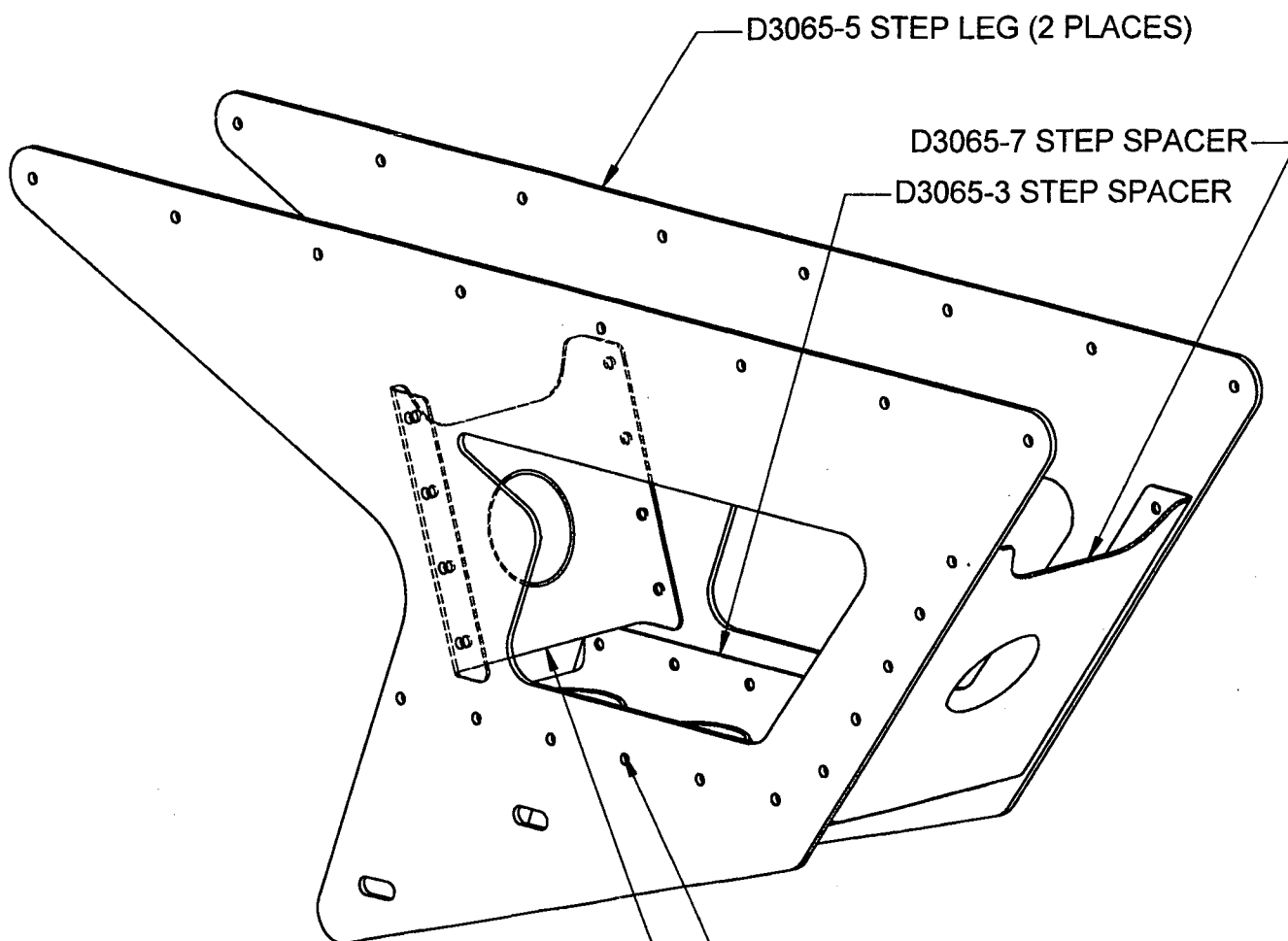
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



D3065-1 STEP SPACER

ASSEMBLE WITH
MS20470AD4-4 RIVET
(30 PLACES)

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WORK ORDER
NO 29978B

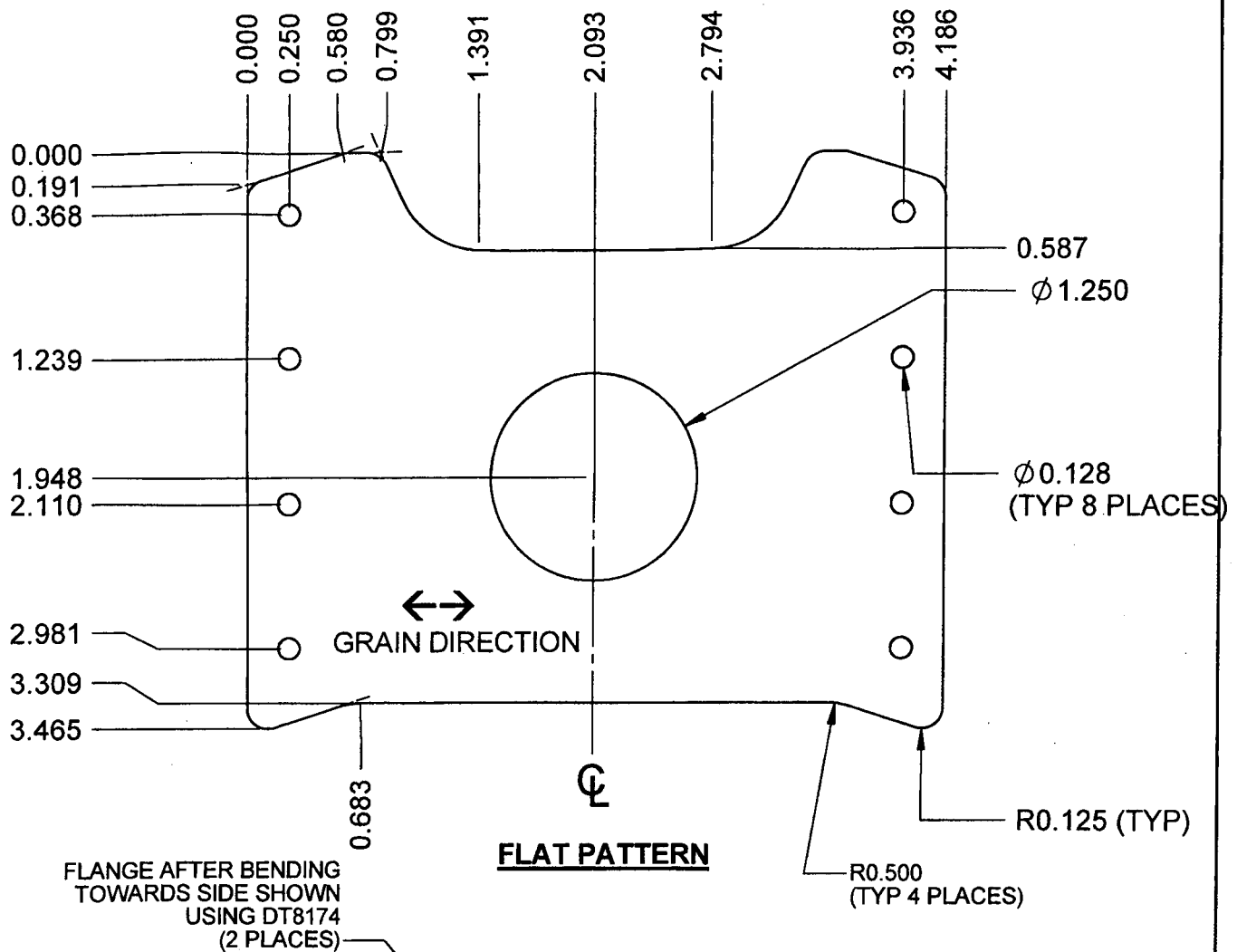
D3065-041 STEP LEG ASSEMBLY

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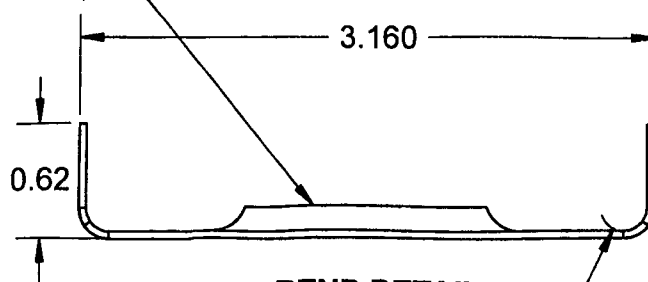


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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



RELEASED

cl. de-20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S:040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

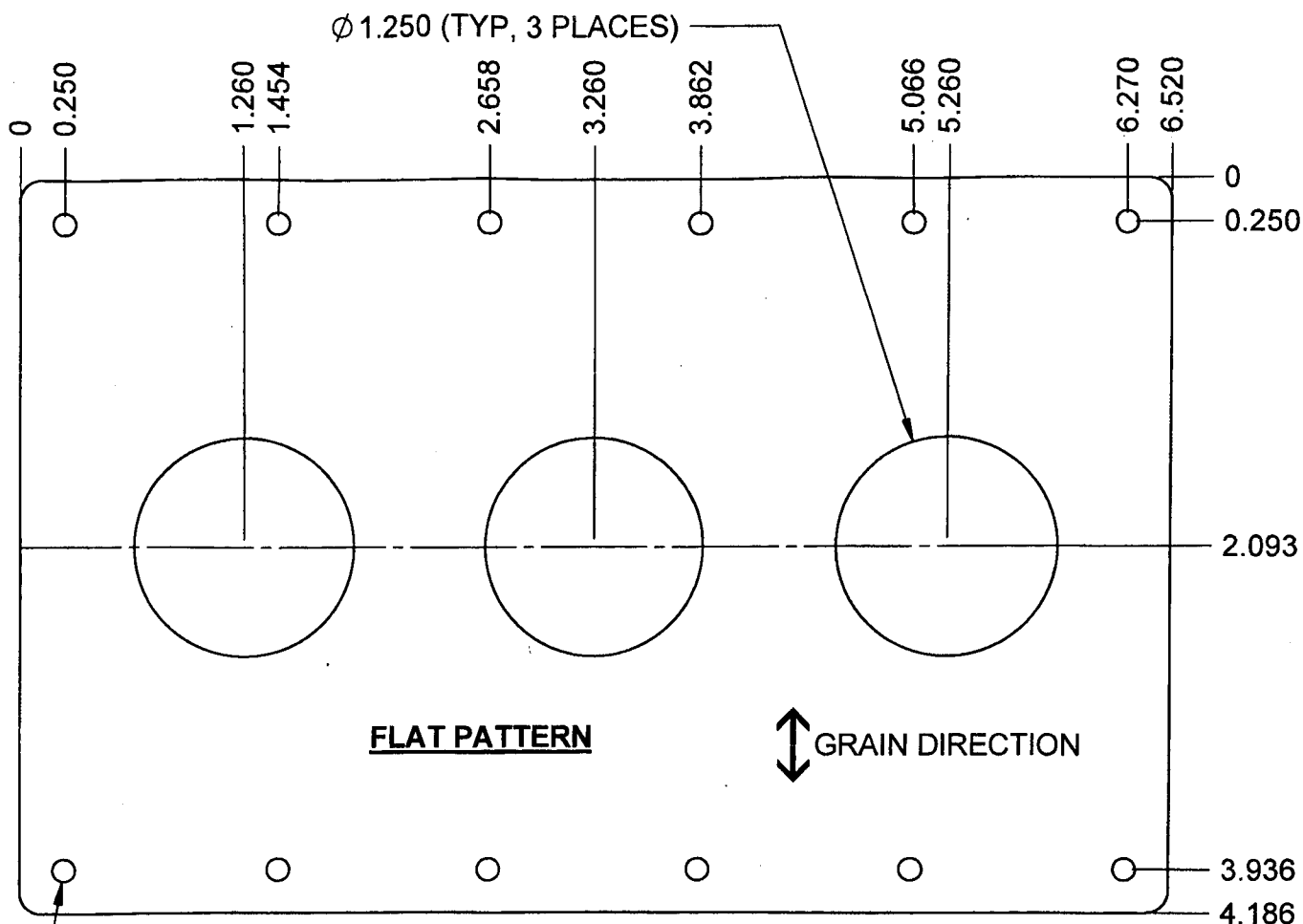
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

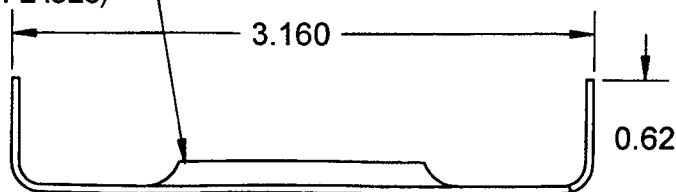


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 06 20



BEND DETAIL

D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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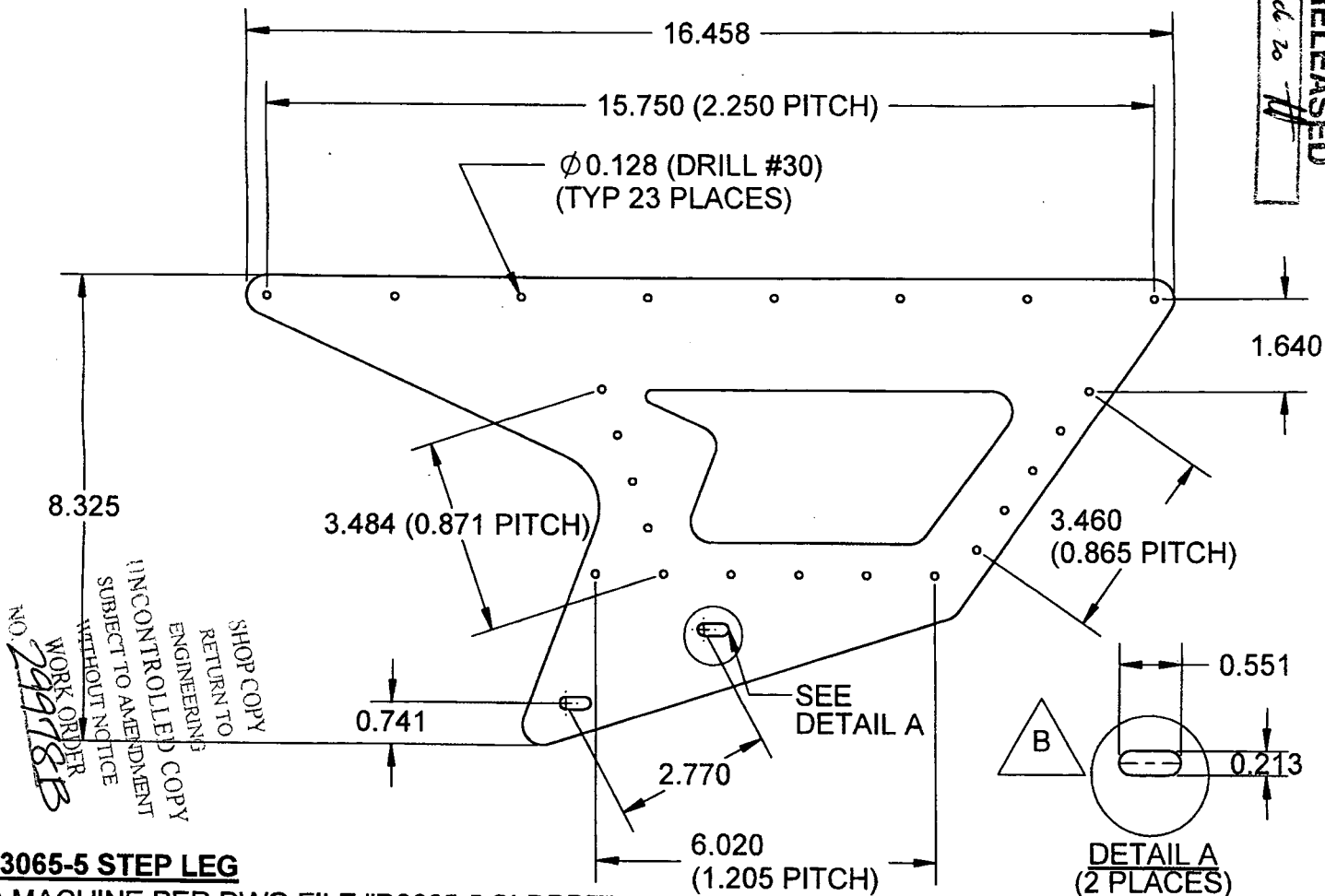
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DART

DESIGN	<i>CP</i>	DRAWN BY	<i>C.B.</i>	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>SH</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3065
DATE	06.05.23			REV. B
		TITLE		SHEET 4 OF 5
		STEP LEG ASSEMBLY	SCALE	
			1:3	

RELEASED

06.06.20 *ff*

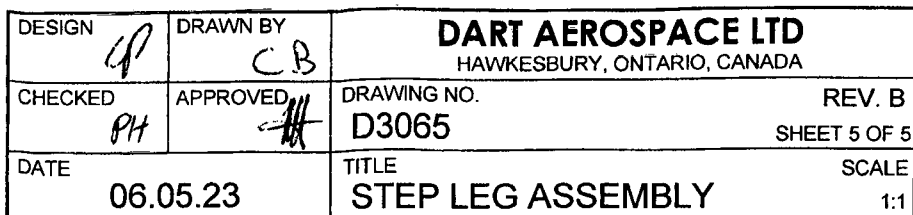


D3065-5 STEP LEG

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES


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FLAT PATTERN

RELEASED

de de re 

0.62

BEND DETAIL

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02473S(040)
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29978B

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S 040)
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
3) PART IS SYMMETRIC ABOUT CENTERLINE
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order:	29978B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 , Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

Prototype

[illegible]

Measured by: <i>mm: mm</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>06/12/20</i>	Date: <i>06/12/20</i>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	